

Friday, 21/12/2007 11:33:15 AM
Linda Lacelle

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 36529 - 2

Estimate Number : 12100

P.O. Number :

This Issue : 21/12/2007 S.O. No. :

Prsht Rev. : NC

First Issue : 1/1 Type : PURCHASED PARTS

Previous Run : 34623

Written By : Checked & Approved By : 

Comment : est rev. A new issue EC

Drawing Name : WHEEL ASSEMBLY

Part Number : D3397041

Drawing Number : D3397 REV.A

Project Number : N/A

Drawing Revision : A

Material :

Due Date : 28/12/2007

Qty: 4/12 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D3397041

wheel ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
wheel ass'y

2.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting PURCHASING
Issue P/O: 5338
Order Part #4997T28 from McMaster-Carr as per Dwg D3397
Ensure Certificate of Conformity is attached

C207/12/21

(12)

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

7/12/27 sp (12x)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK
Ensure certification comply to Dwg D3397

date 08/01/02 (12x)

5.0

LARGE FAB 1

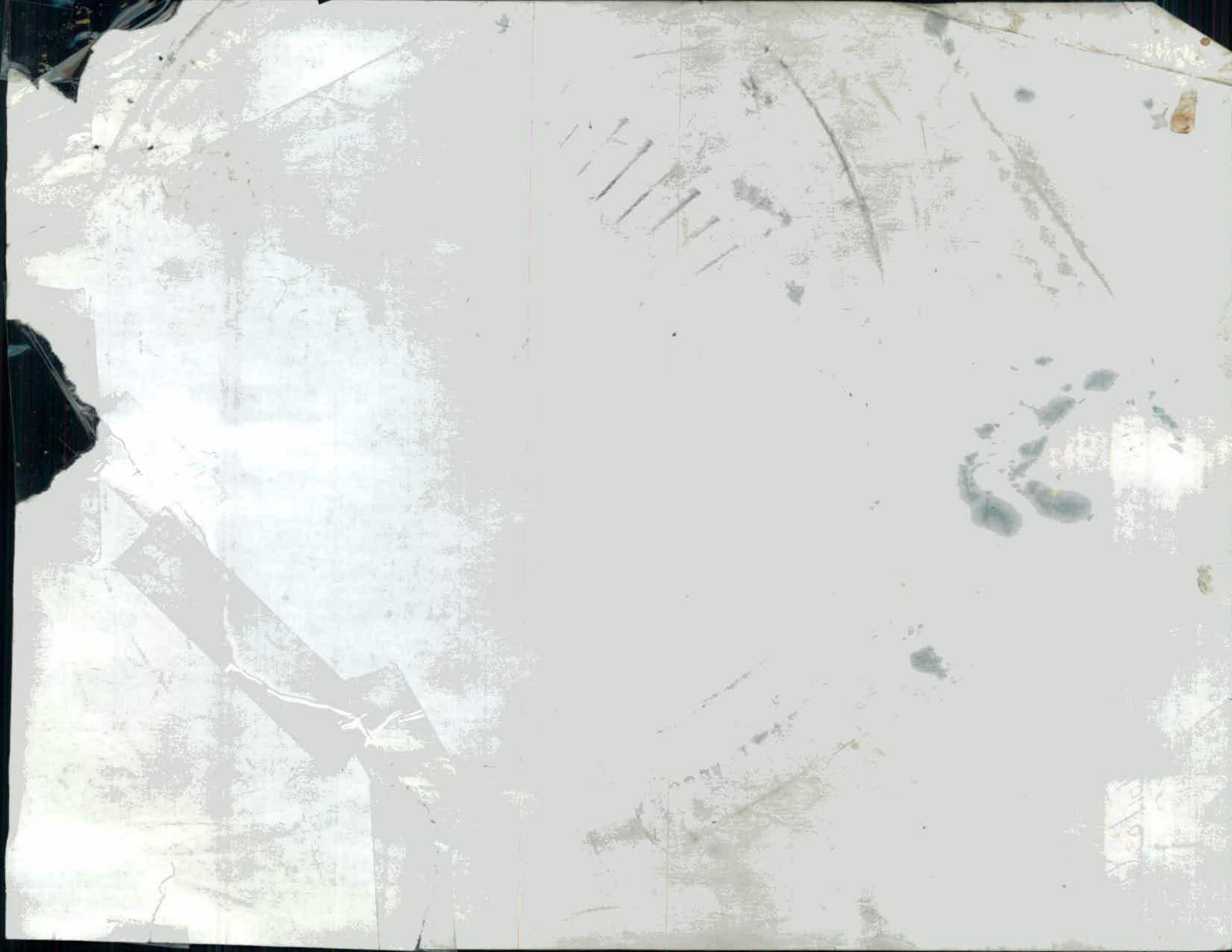
LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Remove retainers and bearing from wheel, do not damage retainers, discard bearing.
2-Ship retainers to machining

* 09/02/03 - Rework
bored cylinders

date 08/01/03 (12x)



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Drawing Name: WHEEL ASSEMBLY

Job Number: 36529

Part Number: D3397041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LATHE CONV.

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE

1-Turn as per Dwg D3397

2-Deburr

IDENTIFY AS D3397-3

Handwritten signature

08 01 04

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten signature
08.01.04

8.0

D33975

sleeve



Comment: Qty.: 1.0000 (s)/Unit Total: 12.0000 (s)

Pick:

Qty	Part number	Description	batch
1	D3397-5	sleeve	B36598

B47656 X6 SAD 09-05-13 (6)

9.0

HK2820

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty	Part number	Description	batch
2	HK2820	bearing	M110576 x12 M110575 - 16

SAD 09-05-13 (6)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Assemble bearing, sleeve and retainers as per dwg D3397

SAD 09-05-13 (6)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/13 (6)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *WA*

SAD 09-05-13 (6)

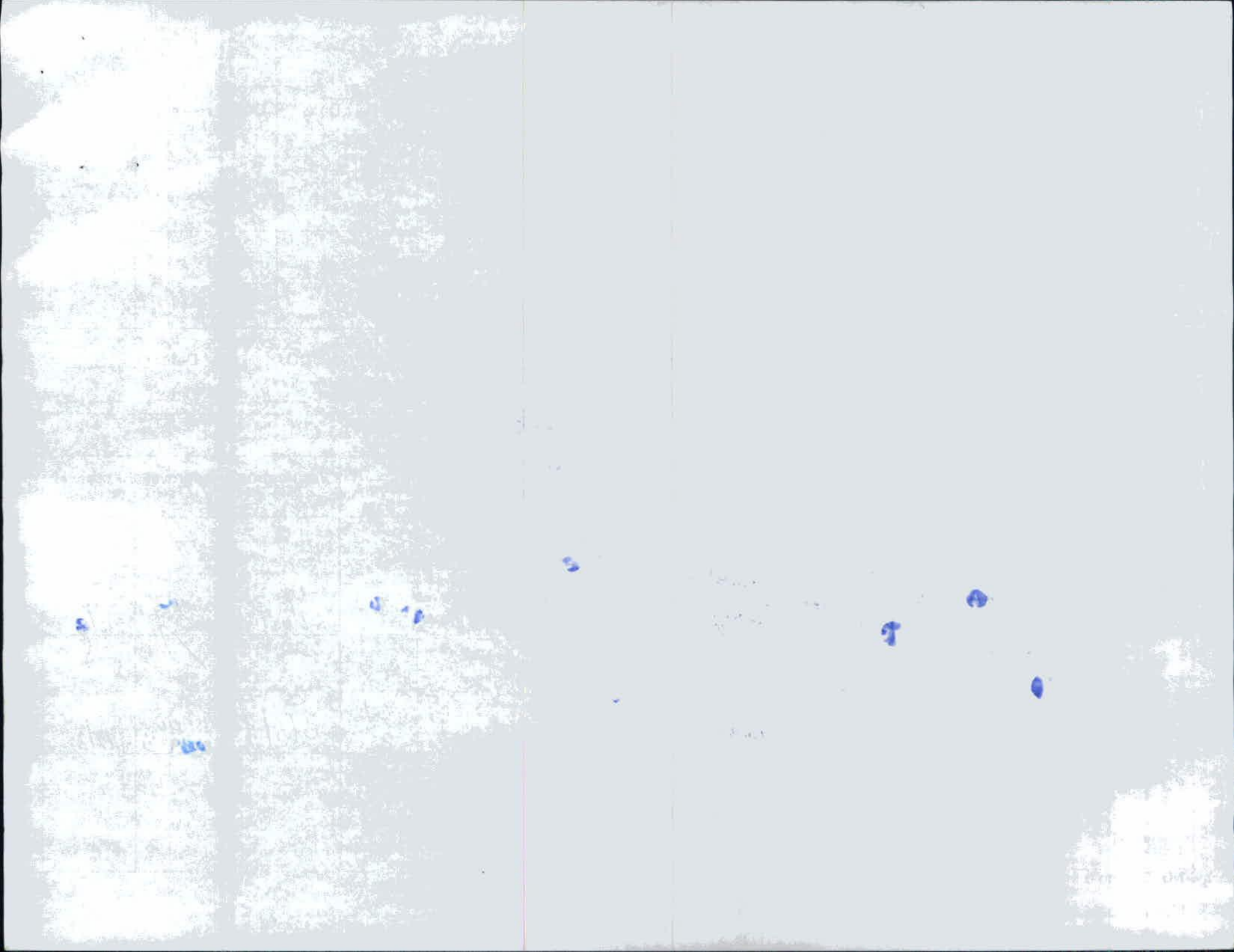


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3397-041 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/05/14
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>36529</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/2/3	# 100	Docking assembly of 2 Qty (X5) wheels it is found that the INT HL2820 needle roller bearing inter-fers with the D3354-3 shaft. QC hub of 1.376" is inconsistent on size. Manufacture.	posiue Level 9	Disassemble hub from rim (Do not lose hardware) Machine hub to f.t. Remove approx. 0.005" to 0.010"	SBD 09/02/03 09/02/03	S 09/05/13	posiue	S 9/2/3
			posiue	try f.t with INT HL2820 bearing and D3354-3 shaft. QC	S 09/02/03	S 09/05/13	posiue Level 9	S 9/2/3

NOTE: Date & initial all entries



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL ASSEMBLY

Job Number: 36529

Part Number: D3397041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/13 *lg*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

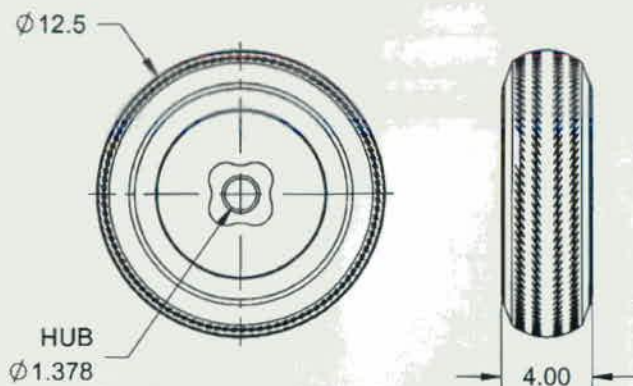


MF 09-05-13





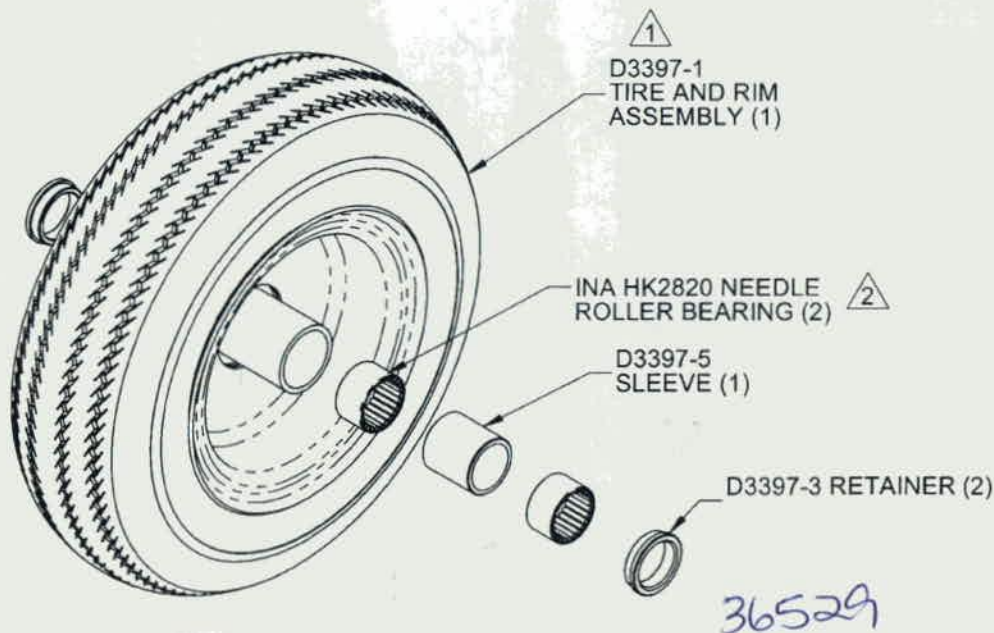
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 5	APPROVED [Signature]	DRAWING NO. D3397	REV. A SHEET 1 OF 3
DATE 05.02.10	TITLE WHEEL ASSEMBLY		SCALE 1:8
A	05.02.10	NEW ISSUE	



1 D3397-1 TIRE AND RIM ASS'Y

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: Ø12.4 X 4.1 RIM: Ø6.0 X 4.0	445 LBS	50 PSI*

RELEASED
06/03/07



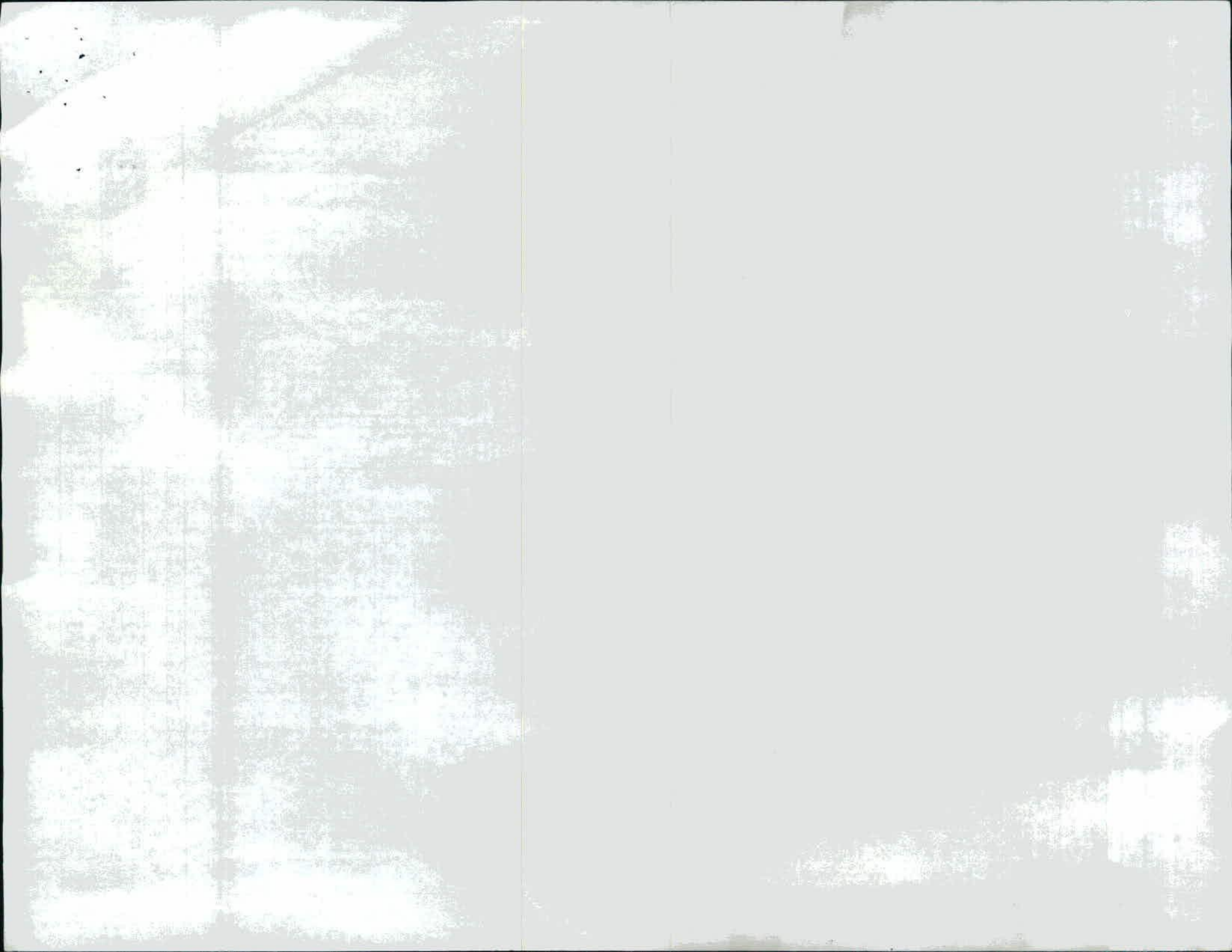
D3397-041 WHEEL ASS'Y

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 4997T28. SCRAP ORIGINAL BEARING
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) INFLATE TIRE TO MAX. 50 psi
- 7) APPLY RUST INHIBITOR NOT PROTECTED BY PAINT. RUST INHIBITOR P/N: LPSC30316

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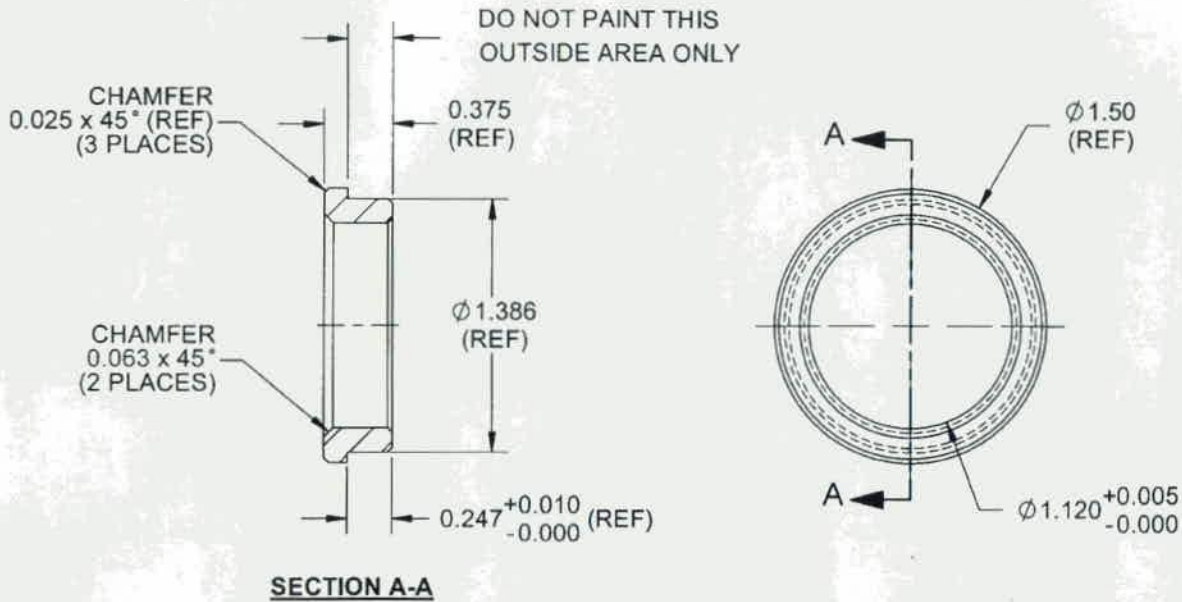


DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3397	REV. A SHEET 2 OF 3
DATE 05.02.10	TITLE WHEEL ASSEMBLY		SCALE 1:1

RELEASED
06/03/09

SPECIFICATION CONTROL DRAWING



D3397-3 RETAINER

36529

NOTES:

- 1) MATERIAL: REMOVE FROM McMASTER-CARR P/N 4997T28 AND MODIFY AS SHOWN
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.025

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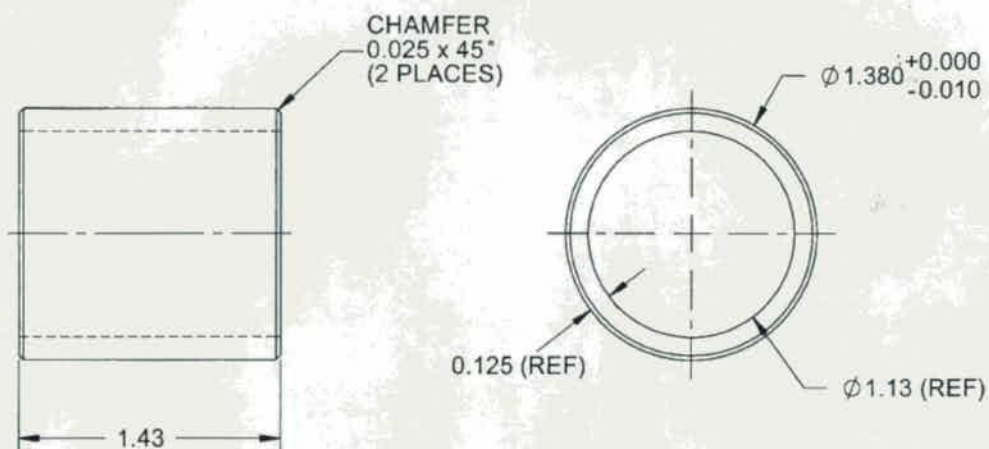
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DESIGN RF	DRAWN BY RE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3397	REV. A SHEET 3 OF 3
DATE 05.02.10	TITLE WHEEL ASSEMBLY		SCALE 1:1

RELEASED
36/03/09



D3397-5 SLEEVE

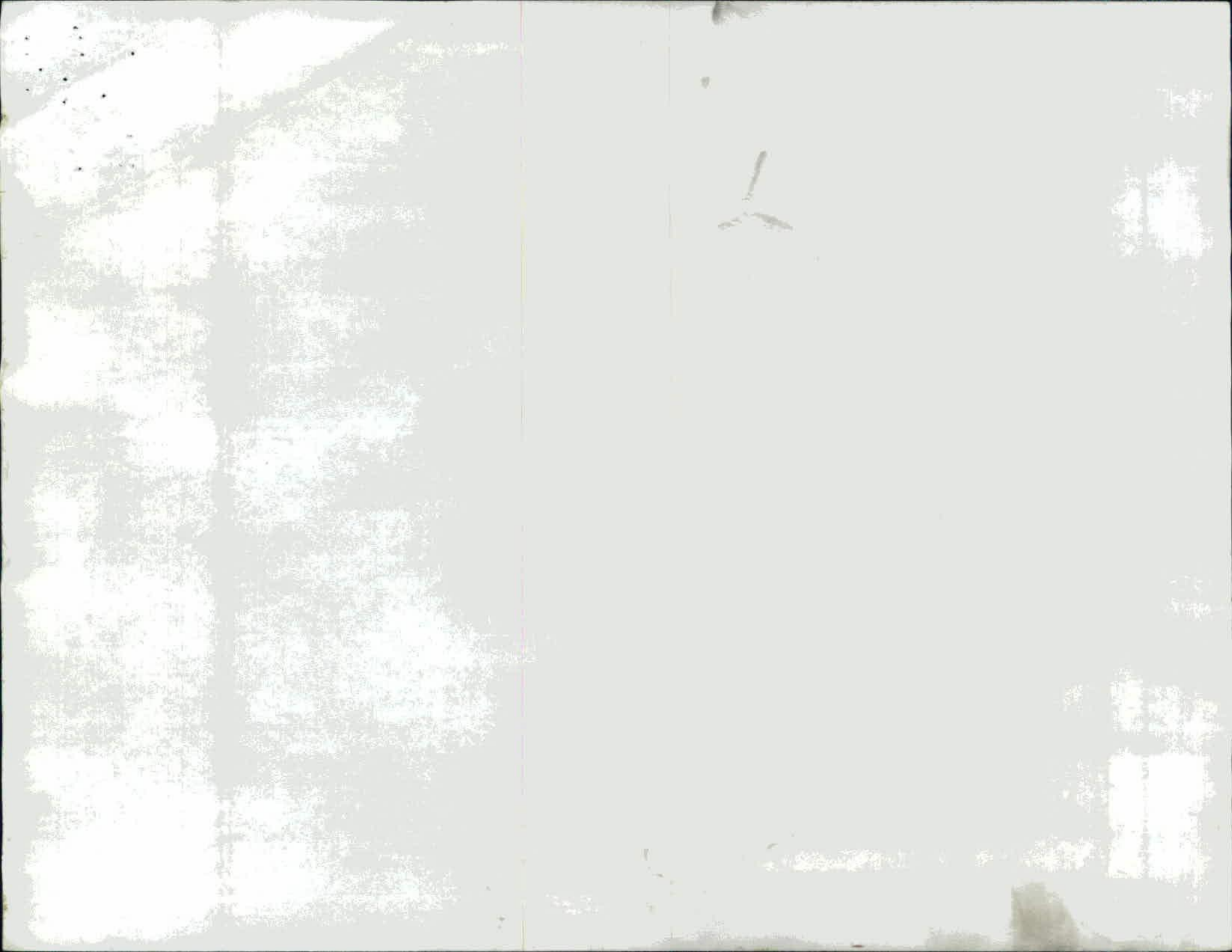
36529

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR1.375W.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.025

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McMASTER-CARR

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Aurora, OH 44202-8087
1-800-995-5500
sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
5338

Page 1

McMaster-Carr Number
4491063-11

12/21/2

Description	Ordered	Shipped
4997T28 Pneumatic Wheel with Two Piece Rim, 12.4" x 3.6", Center Hub, 1" Axle, Roller Bearing, 440 cap	12 Each	12

W=

8 - 97 - 40 91 - 24 T28 12EA

14

9/12/27
SB

OW2

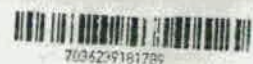


Dart Aerospace Ltd

EXP

99 lbs
1 line

FW1CFV36
12/21/2007
10:51/11:02
379



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